

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018657**Date Inspected:** 15-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Tian Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 1

Heat straightening of PCMK, 20TR2-037, under approved Heat Straightening procedure, HSR (B)-362, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Xiang Feng Feng. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 80mm.

Bay 2

This QA Inspector observed the following work in progress for Bay 2.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Xiang Feng Feng.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Grillage Plate

PCMK: SA7512-001-037

Welder: 066734

WPS-B-T-2233-TC-U5-F

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PCMK: SA7512-001-051
Welder: 066443
WPS-B-T-2233-TC-U5-F

PCMK: SA7512-001-065
Welder: 066421
WPS-B-T-2233-TC-U5-F

Components: Floor Beam
PCMK: FB3343-001-038
Welder: 068859
WPS-B-T-2233-TC-U4b-F

PCMK: FB3343-001-399
Welder: 037748
WPS-B-T-2233-TC-U4b-F

This QA inspector performed Magnetic Particle Testing (MT) and Visual Inspection (VT) of approximately 15 % of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The member(s) is/are identified as follows; Floor Beams for item number 1 of NWIT tracker document # 07367

Bay 3

This QA Inspector observed the following work in progress for Bay 3.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Wang Lian.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Floor Beam
PCMK: SA3286-001-398
Welder: 050242
Report: B-WR16777
WPS-345-FCAW-2G (2F)-Repair

PCMK: SA3286-001-193
Welder: 044830
Report: B-WR16786
WPS-345-FCAW-3G (3F)-Repair

PCMK: SA3286-001-216
Welder: 052686
Report: B-WR16771
WPS-345-FCAW-3G (3F)-Repair

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Heat straightening of PCMK, LD3043, under approved Heat Straightening procedure, HSR1 (B)-9837, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Wang Lian. The approved HSR procedure stated that a maximum temperature of 600°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 8mm.

Bay 6

Heat straightening of PCMK, CB3002C, under approved Heat Straightening procedure, HSR 1(B)-9838, DP3166-001 with HSR 1(B)-9661, The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Huang Min. The approved HSR procedure stated that a maximum temperature of 600°C and 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 8mm and 9.5mm.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
